

Date: Monday, 23/02/2009 3:40:56 PM  
 User: Jean-Luc Menard

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: TOW CAP
<b>Job Number</b>	: 46029		
<b>Estimate Number</b>	: 10483		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D3401041
<b>This Issue</b>	: 23/02/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3401 REV B
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 41931	<b>Drawing Revision</b>	: B
	<b>Type</b> : MACHINED PARTS	<b>Material</b>	:
<b>Written By</b>	: <u>SA 09.02.27</u>	<b>Due Date</b>	: 02/03/2009
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	20
<b>Comment</b>	: Est. A 05.09.01 New issue KJ/JLM	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6R3500	6061 RD bar 3.50
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**Comment:** Qty.: 0.3675 f(s)/Unit Total: 7.3500 f(s)  
 Inventory

7.3 ft

\* 28 inches left \*

Material: 6061-T6 Round Bar (QQ-A-225/8 or QQ-A-200/8)  
 (M6061T6R3.500)

Batch: M106534

SA 09/02/27

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut Blanks 4.20" Long

SA 09/02/27

(20)

3.0	DOOSAN LATHE	DOOSAN LATHE
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**Comment:** DOOSAN LATHE

Turn as per Folio FA532 &amp; Dwg D3401

Folio Rev: N/A

Dwg Rev: B

Deburr

SA 09/02/27

(20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/02/27

(20)

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** Haas #1

Machine as per Folio FA532 and Dwg D3401

Dwg Rev: B

Folio Rev: B

Identify as D3401-1

Deburr &amp; Buff rad as per Dwg D3401

H.A 09/02/28

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Drawing Name: TOW CAP

Job Number: 46029

Part Number: D3401041

Job Number:



Y.A 09/02/28

Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 09/03/02

(20)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill and c'sink using DT8782 as per Dwg D3401

FF 09/03/10

20

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0903.10 (20)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

umo/ br.

09/03/12

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 110939

START TIME:

11:00

OVEN TEMPERATURE:

320°

FINISH TIME:

11:30

BR 09-03-12

(20)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-12 (20)

12.0

NAS1330C3KB116

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Insert

Pick:

Qty Part number

Description Batch

4 NAS1330C3KB116 Insert

M 19472

Assemble as per Dwg D3401

Identify as D3401-041

09-03-18

(20)

Date: Monday, 23/02/2009 3:40:56 PM  
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## Process Sheet

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Drawing Name: TOW CAP

Job Number: 46029

Part Number: D3401041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

09/03/18

X20

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-7

JH

09-03-18

X20

15.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

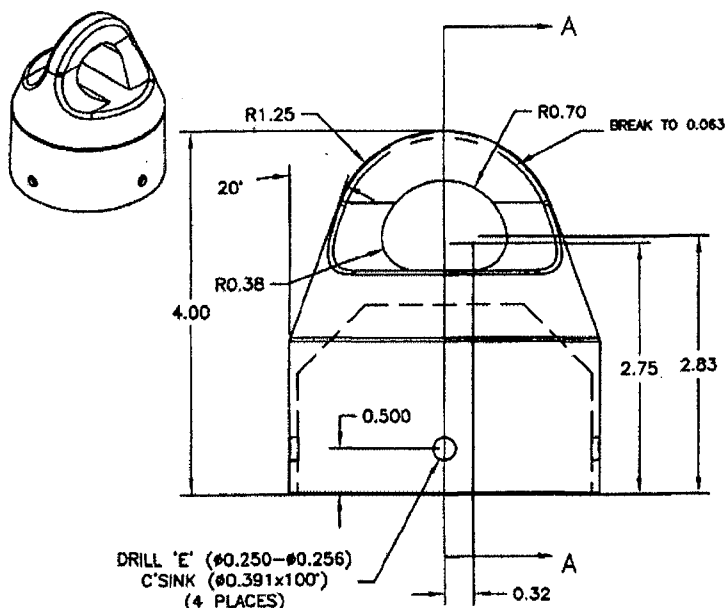


MF

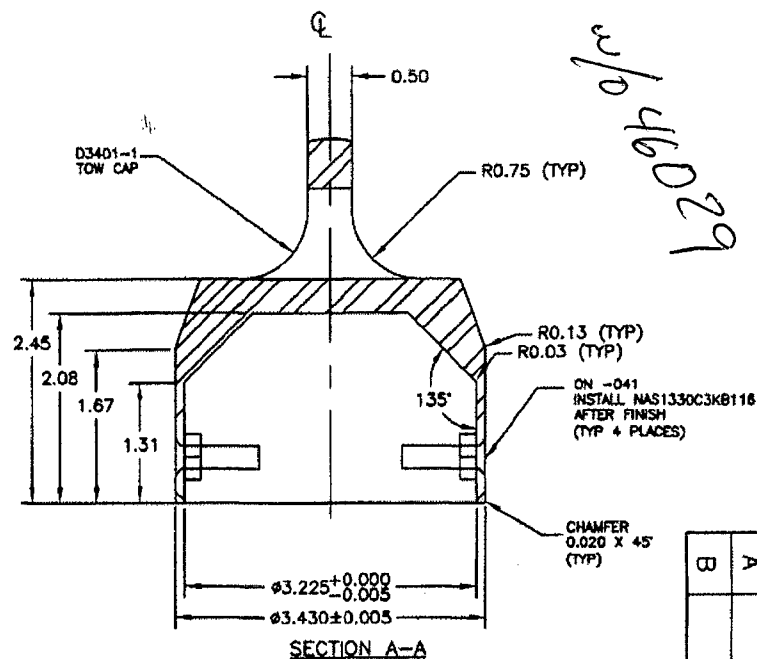
09-03-18



**DART**



**D3401-1 TOW CAP**



**D3401-1/-041 TOW CAP**

**D3401-1 TOW CAP**

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6  $\phi$ 3.500 ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D3401-041 TOW CAP**

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

**D3401-041 TOW CAP PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
PH	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3401
DATE 05.06.09	TITLE TOW CAP	REV. B
A	05.02.24	NEW ISSUE
B	05.06.09	CHAMFER INSIDE, REMOVE RADIUS
SCALE 1:2		SHEET 1 OF 1

RELEASED  
05-08-01